



Dart Aerospace Ltd.
1270 Aberdeen St
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RBW6205G09132-3G

Job Sheet 203573



Part No: RBW6205G09132-3G

Job Qty: 2 pcs

Part Name: Trolley Adapter, Swashplate Support



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/21/19

Job Tracking No:

Due Date: 1/10/20

Created By: Jennifer Renwick

Type: Stock

Description: SIOP

Note: DWG RBW6205G09132-3G Rev 3 IPP Rev A 18.03.27 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	2 pcs	1/10/20		0.00	1.00	Small Fab - 1		ML
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
							Small Fab - 9		
110	QC 5	2 pcs	1/10/20		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 3-1 - Stock - B4B	2 pcs	1/10/20		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		



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Container No: S238947



Part: RBW6205G09132 - 3G

Job No: 203573

Serial No/Batch: S238947

Revision: 3

Inspector:

Exp Date:

Instructions:

Date: 12/10/19

DAS
40
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				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	DA
				Packaging 3 - 7 - B4B	2
				Packaging 3 - 8 - B4B	9-89
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAE
140 QC 21 - FG	2 pcs	1/10/20	0.00 0.00	QC 21 - FG - 21	21
				QC 21 - FG - 70	2-8
				QC 21 - SA - 53	

DEC 11 2019

DEC 11 2019

GA
Corner

Part Op 100 - Small Fab - 1-Engrave RB41011 placard using marktronic etcher 2-Assemble as per DWG.
 Descriptions: 110 - QC5- Inspect part completeness to step on W/O
 130 - Identify as per dwg & Stock Location: _____
 140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RB41011	Dart Tooling Placard, Aluminum	2 pcs (1 ea)	100-Small Fab - 1	3021040
171 RBW6205G09132-3G-1	Base	2 pcs (1 ea)	100-Small Fab - 1	3079981
925 RBW6205G09132-3G-3	Block	6 pcs (3 ea)	100-Small Fab - 1	5160900
94 RBW6205G09132-3G-5	Wear Plate	6 pcs (3 ea)	100-Small Fab - 1	513107 5115405
94 RBW6205G09132-3G-7	Pin	6 pcs (3 ea)	100-Small Fab - 1	5137465
94 RBW6205G09132-3G-9	Arm Weldment	6 pcs (3 ea)	100-Small Fab - 1	5123107
64 90126A029	Washer 1/4"	12 Ea (6 ea)	100-Small Fab - 1	5116848
67 91166A270	Washer, M8	18 Ea (9 ea)	100-Small Fab - 1	5128824
66 91180A540	Screw M8 X 1 X 10Mm	18 Ea (9 ea)	100-Small Fab - 1	5116834
67 91420A324	Screw M5 X .8 X 14Mm	18 Ea (9 ea)	100-Small Fab - 1	5116828
52 91654A076	Drive Screw #2 3/16" Long	8 Ea (4 ea)	100-Small Fab - 1	5015391
70 92620A539	Screw 1/4-20 X 5/8	12 Ea (6 ea)	100-Small Fab - 1	5116835
43 98335A058	Hairpin Cotter Pin	6 Ea (3 ea)	100-Small Fab - 1	5116842

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	90126A029	12	220	0
	91166A270	18	101	0
	91180A540	18	50	0
	91420A324	18	100	0
	91654A076	8	10	0
	92620A539	12	100	0
	98335A058	6	50	0
	RB41011	2	219	0
	RBW6205G09132-3G-1	2	6	0
	RBW6205G09132-3G-3	6	6	0
	RBW6205G09132-3G-5	6	15	0
	RBW6205G09132-3G-7	6	11	0
	RBW6205G09132-3G-9	6	6	0

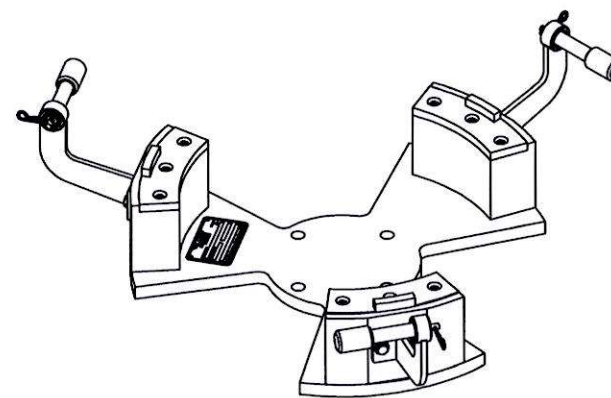
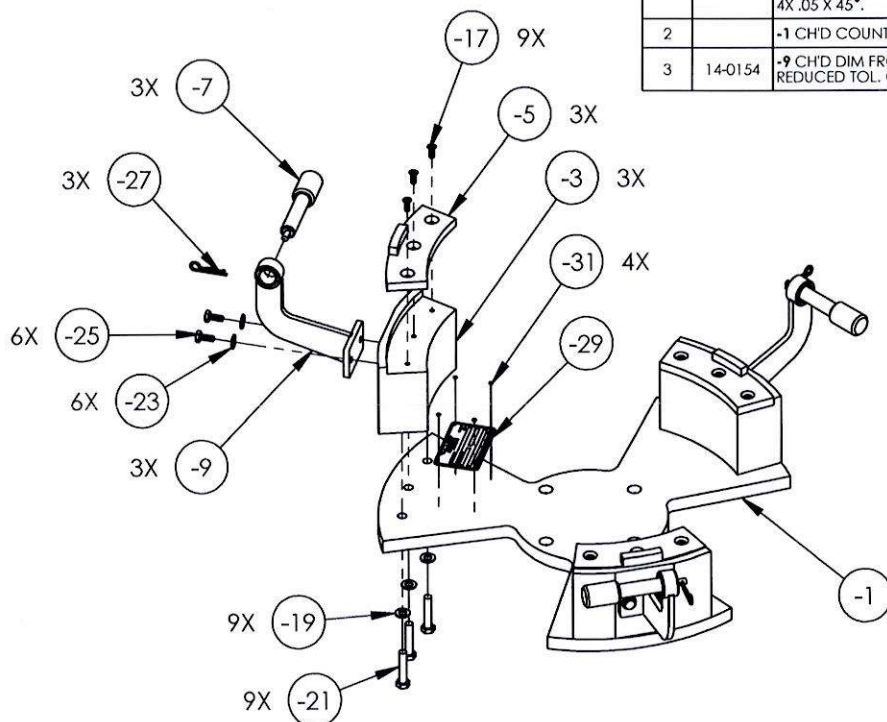
Part Specifications

Specifications could not be found.

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVAL
1		-1 CH'D COUNTERBORE WAS .594 ∇ .390 IS .594 ∇ .39. -3 CH'D HOLE DEPTHS WAS .394 IS .39, WAS 1.000 IS 1.00, WAS .625 IS .63. -7 ADDED NOTE "CENTER OK". -13 CH'D CHAMFER WAS 4X .050 X 45° IS 4X .05 X 45°.	6/25/2013	BIM	GE
2		-1 CH'D COUNTERBORE HOLES FROM $\varnothing$ 5.375 B.C. TO $\varnothing$ 5.512 B.C.	7/19/2013	RJC	RW
3	14-0154	-9 CH'D DIM FROM 4.164 TO 3.92. -11 CH'D DIM FROM 4.562 TO 4.32. UPDATE TITLE BLOCK TO DART, REDUCED TOL. ON NON-CRITICAL DIMS.	9/19/2014	JAG	DW



ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	BASE	6061	5/8 X Ø18-3/4	2
			-3	3	BLOCK	6061	2-3/8 X 3-5/8 X 6-3/8	3
			-5	3	WEAR PLATE	WHITE NYLON	1 X 2-5/16 X 6-1/8	4
			-7	3	PIN	6061	Ø1 X 4-3/4	5
	X		-9	3	ARM WELDMENT			6
	1		-11		ARM	1018	1/4 X 4-1/4 X 4-1/2	7
	1		-13		RING	1018	Ø1-3/16 X 7/8	8
	1		-15		PLATE	1018	3/8 X 1-5/8 X 2-1/2	9
		B/O	-17	9	FLATHEAD SCREW	STEEL	M5 X .8 X 14mm MCMaster-CARR #91420A324	1
		B/O	-19	9	WASHER	STEEL	M8 MCMaster-CARR #91166A270	1
		B/O	-21	9	SCREW	STEEL	M8 X 1 X 40mm MCMaster-CARR #91180A540	1
		B/O	-23	6	WASHER	STEEL	1/4 MCMaster-CARR #90126A029	1
		B/O	-25	6	SCREW	STEEL	1/4-20 X 5/8 MCMaster-CARR #92620A539	1
		B/O	-27	3	HAIRPIN COTTER PIN	STEEL	MCMaster-CARR #98335A058	1
		B/O	-29	1	DART PLACARD	ALUMINUM	RB41011	1
		B/O	-31	4	#2 DRIVE SCREW	COATED STEEL		1
	ASSY -9							

NOTE:
ENGRAVE -29 PLACARD WITH T/N, S/N, "MADE
IN USA".



DART
AEROSPACE

TITLE	TROLLEY ADAPTER, SWASHPLATE SUPPORT
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DWG NO.	
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RBW6205G09132-3G

REV	3
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	MAT'L
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DRAWN BY: GILBERT

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES

.XXX	± .005	FRACTIONS ± 1/8
.XX	± .01	ANGLES ± .5°
.X	± .1	

D	APPROVED	<i>D Weil</i>
	HEAT	
	TREAT	
	FINISH	
	CRACK	

1. BREAK ALL SHARP EDGES .015 x 45
OR .015R
2. DIMENSIONAL LIMITS APPLY AFTER
PLATING

15	SPEC
R	USED ON MODEL
	AW139

SCALE	1.8
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1.8

DATE	1/19/2012
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SHEET 1 OF 9